

**Work Order ID 72913**

Monday, October 24, 2011 1:48:28 PM

**\*72913\*****DUPLICATE** Page 1

Item ID: D206-628-031

Accept

**\*N9000040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli-Access-Step LH

Start Date: 8/18/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *11-10-24*

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-031 CHG 003

*8 u/w/26**for MLT 11-10-24*  
*(2)*

110

0.00

**\*110\***

Pick Kit

Packaging

Memo

0.00

Packaging

*80 11-10-24.*

120

0.00

**\*120\***

QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8 u/w/26**42**44*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72913

**\*72913\***

Page 2

Monday, October 24, 2011 1:48:28 PM

Item ID: D206-628-031

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step LH

Start Date: 8/18/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-031								
	Location: <u>      </u>								
	PPP Rev: <u>      </u>								
140									
<b>*140*</b>	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*Sep 11-10-26*

*11/10/26*

*11-10-26*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, October 24, 2011 1:48:28 PM

Page 1

Work Order ID: 72913

Parent Item: D206-628-031

Parent Item Name: Heli-Access-Step LH

Start Date: 8/18/2011

Required Date: 8/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM  
IPP RevE as per ecn 1118 08-02-05 DD verified by:EC IPP Rev:F as per chg 003 DD  
10.02.25 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-13A Bolt		Purchased	No			110	Each	1,136.0000	8				
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST357		1136							
				118078		590							
				118706		46							
				118838		500							
AN4-14A Bolt		Purchased	No			110	Each	223.0000	8				
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST357		223							
				118628		100							
				118706		23							
				119127		100							
AN4-15A Bolt		Purchased	No			110	Each	559.0000	8				
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST358		559							
				118112		4							
				118648		255							
				118706		200							
				119127		100							
AN960JD416 Washer	NAS1149D0463J	Purchased	No			110	Each	0.0000	12				
D2724-041 206L Step Assembly		Manufactured	No			110	Each	0.0000	1				

m119042

12 sp 11-10-24  
1 72914 11/10/26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Monday, October 24, 2011 1:48:28 PM

Page 2

Work Order ID: 72913

Parent Item: D206-628-031

Parent Item Name: Heli-Access-Step LH

Start Date: 8/18/2011

Required Date: 8/25/2011

Start Qty: 2.00

Required Qty: 2.00

D2731-3  
Mounting Lug

Manufactured No

110 Each 108.0000

8

Location

Loc Qty

Loc Code

ST469

108

47967

5

52329

23

73417

80

8x

542

\* D2732-030  
Rubber Cushion

Manufactured No

110 Each 4.0000

8 B 73759 16x SP

Location

Loc Qty

Loc Code

ST409

4

56515

0

64283

4

D3394-041  
Lug Assembly

Manufactured No

110 Each 74.0000

8 SP

Location

Loc Qty

Loc Code

ST474

74

73418

34

74505

40

8x

MS21042L4  
Nut

Purchased No

110 Each 13,733.0000

12 24 SP 11-10-24

Location

Loc Qty

Loc Code

ST300

2733

117441

51

117601

537

118451

1145

118927

1000

24x

ST516

6000

119017

6000

ST518

5000

119075

5000

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Shop Packet Print

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-628  
Page 17 of 19

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS-  
STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

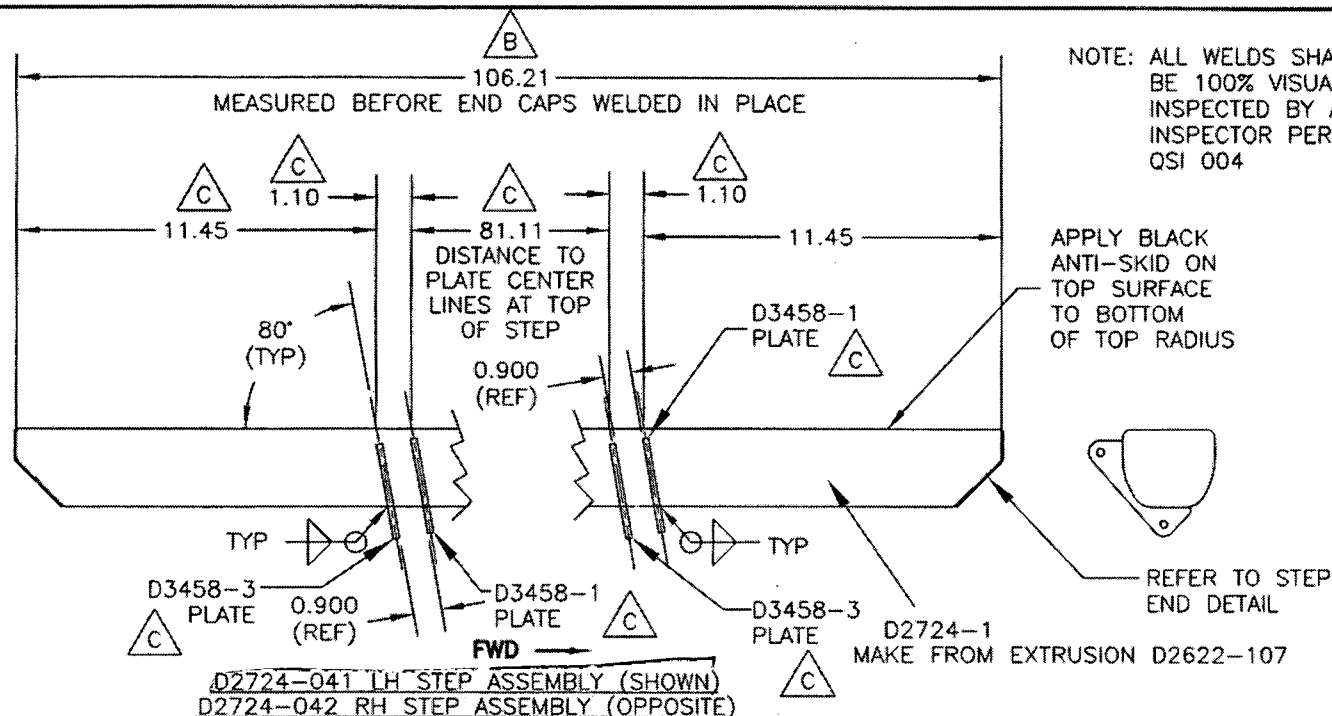
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Revision: G  
Date: 11.02.25

**DART**

PREPARED  
REFERENCE ONLY

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004

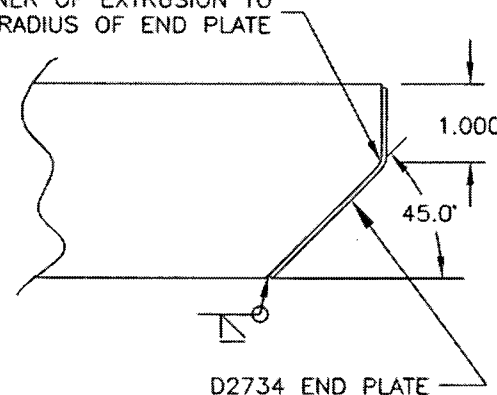


APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

REFER TO STEP  
END DETAIL

D2724-1  
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



#### D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

#### D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	206L/407 STEP ASSEMBLY	REV. C
				SHEET 1 OF 1
				SCALE
				NTS
				RE-DESIGN, ADD D3458-1/-3
				UPDATED WELD DETAIL REVISED TOLERANCES
				NEW ISSUE
				97.12.04
				98.10.19
				05.09.19